

Work Order ID 62296

Friday, September 24, 2010 3:08:52 PM



Page 1

Item ID: D4106-5

Accept



Setup Start



Revision ID:

Item Name: Spacer, Sill Doulber

Stop



Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-9-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4106

A

100

0.00



Waterjet

Memo

0.00

B10-9-27

FLOW CNC Waterjet

Kydex STEEL GREY1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary



110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B10-9-27

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Page 2

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Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S10/09/22



130



Packaging

Packaging

Identify as per dwg & Stock Location: 127

0.00

0.00

10/09/22 (5)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/09/22 (8)

10/09/22 (5)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Friday, September 24, 2010 3:08:52 PM

Page 1

Work Order ID: 62296



Parent Item: D4106-5



Parent Item Name: Spacer, Sill Doulber

Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MKYD6185S.080-P3- 52068 | | Purchased | No | | | 100 | sf | 394.8600 | 0.2109 | 0.666 | 1.3 | | |

Kydex steel grey



10-9-27

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| therm | 394.86 | |
| 111807 | 394.86 | |

111807

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

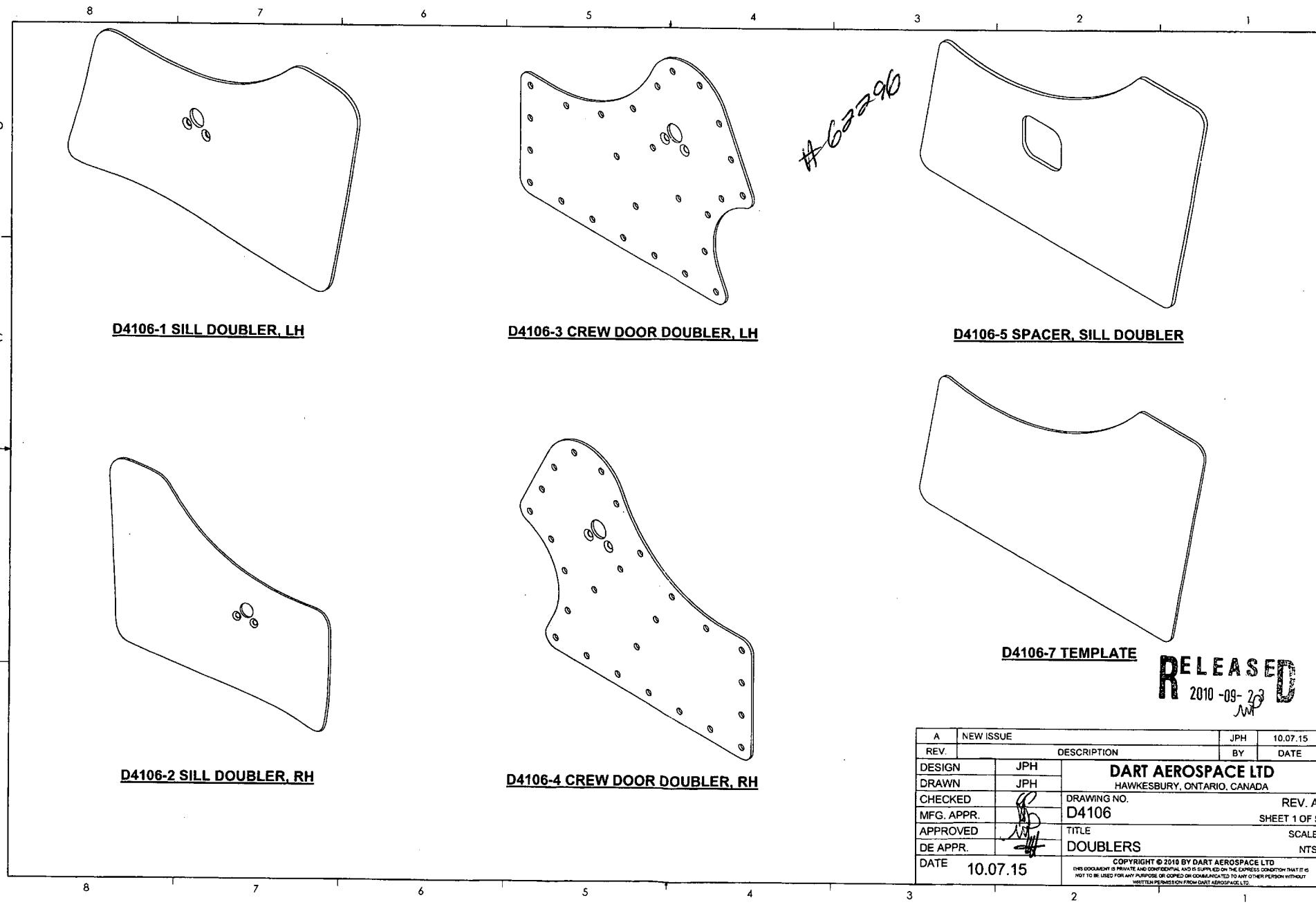
| | | |
|----------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 62296 |
| Description: SPACER SILL DOUBLER | Part Number: | D4106-5 |
| Inspection Dwg: D4106-5 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

x First Article **Prototype**

| | | | | | |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | 13 | Audited by: | S | Prototype Approval: | N/A |
| Date: | 10-4-07 | Date: | 10/09/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



| A | NEW ISSUE | | JPB | 10.07.15 |
|------------|--------------------|-----------------------------|-------|----------|
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | JPB | DART AEROSPACE LTD | | |
| DRAWN | JPB | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | | |
| MFG. APPR. | <i>[Signature]</i> | D4106 | | |
| APPROVED | <i>[Signature]</i> | REV. A | | |
| DE APPR. | <i>[Signature]</i> | SHEET 1 OF 5 | | |
| DATE | 10.07.15 | | SCALE | NTS |
| DOUBLERS | | | | |

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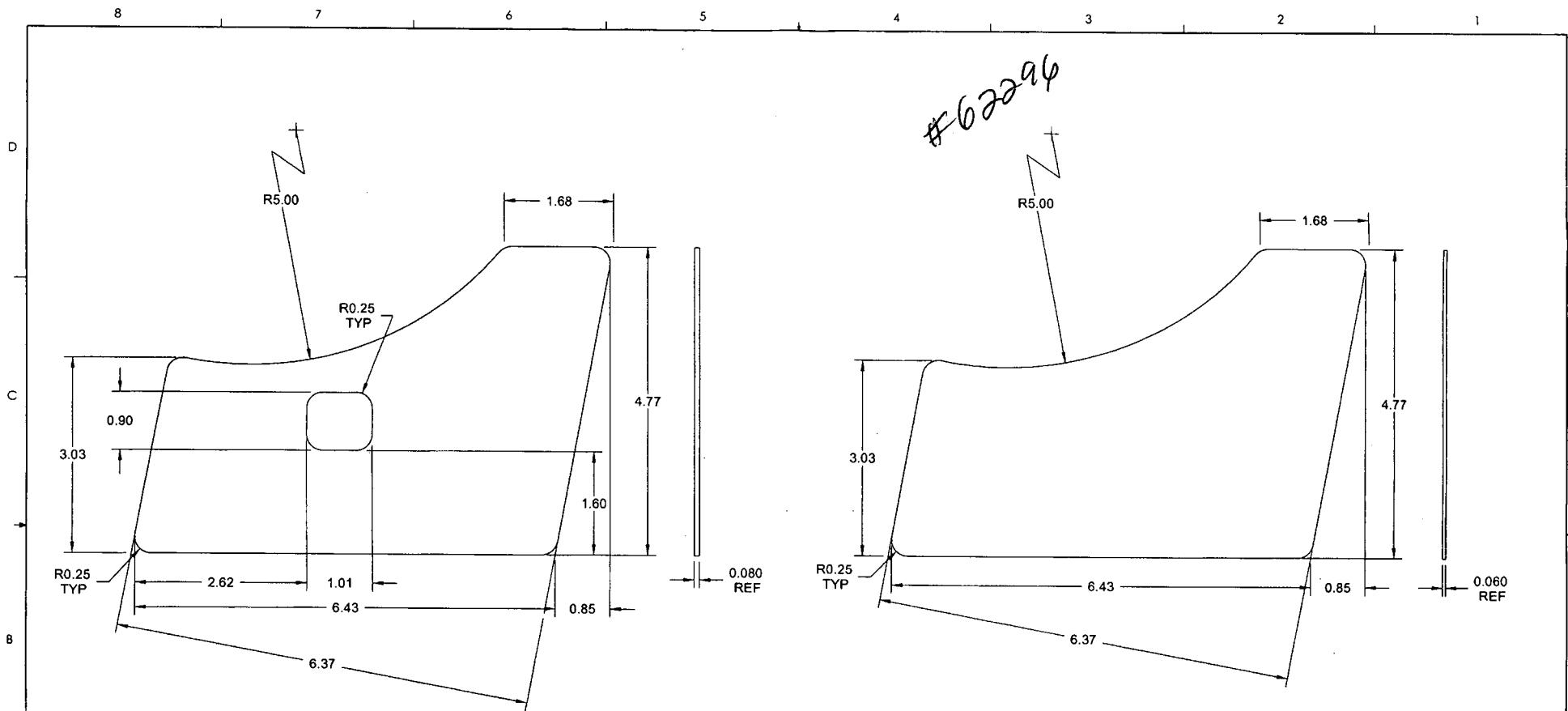
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
-7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A

RELEASED
2010-09-23
JW

| DESIGN | JPH | DART AEROSPACE LTD | |
|------------|-----------|--|--------------|
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>JW</i> | DRAWING NO. | REV. A |
| MFG. APPR. | | D4106 | SHEET 5 OF 5 |
| APPROVED | <i>JW</i> | TITLE | SCALE |
| DE APPR. | <i>JW</i> | DOUBLERS | NTS |
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